

Date: Friday, 19/01/2007 8:50:26 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DND001 Department of National		Drawing Name	: STIFFENER		
Job Number	: 30323					
Estimate Number	: 12652					
P.O. Number	: N/A			Part Number	: G106044	
This Issue	: 19/01/2007		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Number	: G10604 REV A	
First Issue	: N/A		Type	: SMALL /MED FAB		
Previous Run	: N/A			Project Number	: N/A	
Written By	:			Drawing Revision	: A	
Checked & Approved By	:			Material	: N/A	
Comment	: Est Rev:A New Issue 07-01-18 JLM					
Due Date	: 26/01/2007			Qty:	10	Um: Each

Additional Product

REPLACE

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S050	2024-T3 .050 sheet	
		Comment: Qty.: 0.4430 sf(s)/Unit Total : 4.4300 sf(s) 2024-T3 .050 sheet m 103321 Batch: M103210	
2.0	WATER JET	FLOW WATER JET	
			(10)
		Comment: FLOW WATER JET 1-Cut as per Dwg G10604 Dwg Rev: A Prog Rev: G106044	
			(10)
		2-Deburr if necessary	
		****USE SAME CUTTING FILE FOR -4 & -5****	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			(10)
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
			(10)
4.0	QC8	SECOND CHECK	
			(10)
		Comment: SECOND CHECK	
			(10)
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C'sink as per Dwg G10604 C'sink .128" Dia Holes To Ø.225" Dia X 100°	
		FF 07-01-22	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DP Date: 07/03/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/01/2007 8:50:26 AM
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Process Sheet

Customer: CU-DND001 Department of National

Drawing Name: STIFFENER

Job Number: 30323

Part Number: G106044

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Formas per Dwg G106044

813 07/01/22

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG
07/01/23 (10)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



07/01/01

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

28/4L FL 07/01/24 (10)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

27/1/24 10

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

(10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/05 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

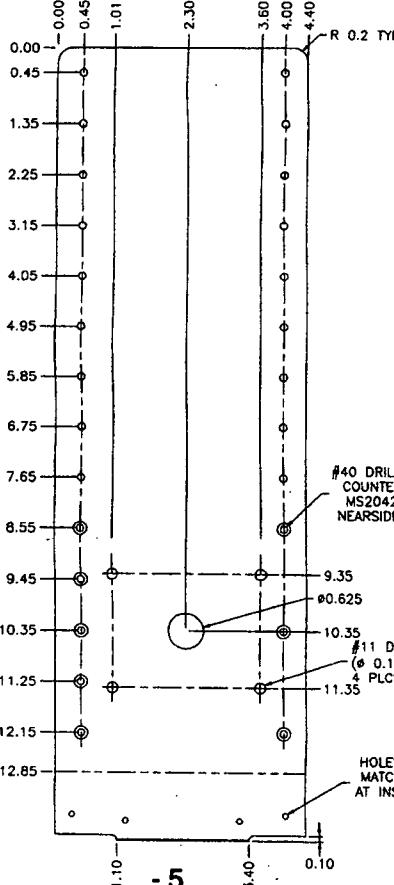
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

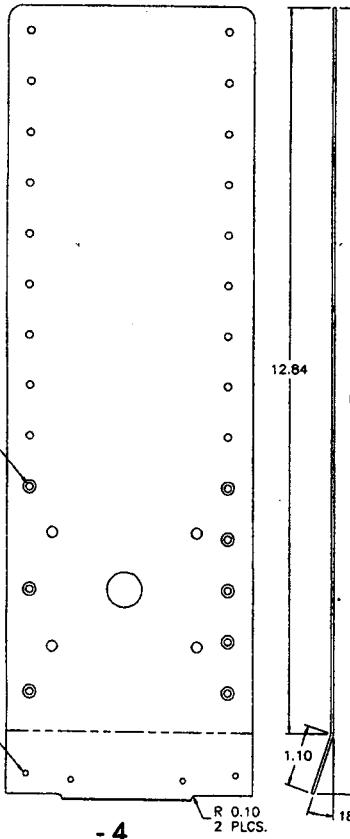
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Wlo 30322



-4 AND -5 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED



-6 R 0.2 TYP. -
-3 AND -6 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED

NOTES.

NOTE:

1. MAT'L: ALUM 0.050 THICK. 2024-T3
QQ-A-250/4

2. ALL PILOT HOLES ARE #40 DRILL (.00.098).
TO BE DRILLED TO SIZE AT ASSEMBLY.

3. FINISH: ETCH, ALODINE PER MIL C5541-1A

BREAK ALL EDGES		DRAWN		DATE		GENEVA AVIATION	
UNLESS OTHERWISE SPECIFIED		T. S.		3/20/95		 10108 - 32nd Ave W Everett, WA 98204 (425)353-7400 FAX/(425)347-7100	
DIMENSION ARE IN INCHES		CHECK		DATE		TITLE	
DIMENSIONAL TOLERANCES		DESIGN		DATE		REAR SHOULDER HARNESS	
3 DECIMALS $\pm .010$		APPROVAL		DATE		STIFFENER	
2 DECIMALS $\pm .020$		RCC		4/3/95			
1 DECIMAL $\pm .050$							
ANGULAR $\pm 1^\circ$							
THIS DRAWING INCLUDES INFORMATION PROPRIETARY TO GENEVA AVIATION INC. IT IS NOT TO BE USED OR REPRODUCED BY ANYONE WITHOUT THE WRITTEN PERMISSION OF GENEVA AVIATION INC.							
				DRW NO.	G10604		REV. A
				PRD NO.	GA159		
					SCALE	D 1/1	SHR. 1/1

DART AEROSPACE LTD	Work Order:	30323
Description:	Part Number:	G 106 044
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	Ø0.128	✓		Vern	
Ø0.625	+0.008/-0.001	Ø0.624	✓		Vern	
Ø0.191	+0.005/-0.001	Ø0.191	✓		Vern	
1.10	1.00 max	1.00 1.00	✓		Vertical	
3.90	±0.030	3.90	✓		Vertical	
4.40	±0.030	4.40	✓		Vern	
0.45	±0.030	0.45	✓		Vern	
1.01	±0.030	1.00	✓		Vern	
2.30	±0.030	2.30	✓		Vern	
3.60	±0.030	3.66	✓		Vern	
4.00	±0.030	4.00	✓		Vern	
0.45	±0.030	0.45	✓		Vern	
1.35	±0.030	1.35	✓		Vern	
3.15	±0.030	3.15	✓		Vern	
4.95	±0.030	4.95	✓		Vern	
7.65	±0.030	7.65	✓		Vern	
9.35	±0.030	9.35	✓		Vern	
11.35	±0.030	11.35	✓		Vern	
0.040	±0.010	0.050	✓		Vern	
					Flora	
					Ve	

Measured by:	SA1	Audited by:		Prototype Approval:	
Date:	07/01/22	Date:	07/01/22	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD	Work Order:	30323
Description: Stiffener	Part Number:	G10604-4
Inspection Dwg: G10604 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: <u>mpf.mel</u>	Audited by: <u>AB</u>	Prototype Approval: _____
Date: <u>07/01/29</u>	Date: <u>07/04/29</u>	Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

M 2024T3 5050

M103210

SHIP TO:						
1000 E. 25th Street Spokane, WA 99205						
SOLD TO:						
TRACIC, LLC						
CUST. PO NUMBER: N18187		WORK PACKAGE:	CUST. PART NUMBER:		SHIP/UNLOAD ID: 100020/10	SAFETY CONTRACT NUMBER:
KAISER ORDER NO: 1033882	LINE ITEM: 1	SHIP DATE: 24-MAR-2008	ALLOY: 2024	CLAD: CLAD	TEMPER: T3	
WEIGHT SHIPPED: 7885 LB	QUANTITY: 223 PCS EST.	ST. NUMBER: 207855	GAUZE: 0.0500 IN	WIDTH: 48.000 IN	LENGTH: 1-4,000 IN	

KAISER

ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4062814

Certified Specifications

AMS 4041/RevP
BATS 2505/RevNC

AMS QQ-A-2505/RevA
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Lot: 350042AB Cast 318

Drop 16

Ingot 2

Test Results

Tensile: Tempor	T3	Dir / # Tests	LT / 2 (Min:Max)	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
				63.8 : 64.7 ✓ (441 : 446)	44.8 : 45.8 ✓ (309 : 316)	15.3 : 13.6 ✓

MRS Deflection: 0.017 IN

Chemistry: Actual	Si / 0.09	FE / 0.24	CU / 4.57	MN / 0.59	MG / 1.40 ✓	CR / 0.01 ✓	ZN / 0.19 ✓	TI / 0.02 ✓	V / 0.01 ✓	ZR / 0.01 ✓	OTHER / 0.04	TOT
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ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.80	1.80	0.10	0.26	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.08	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS) / CHEMICAL MILLING QUALITY (CMQ) REQUIREMENTS.



Page 1 of 2

SHIP TO:
COPPER & BRASS
1715 WOODLAND DR.
SALINE, MI 48176

SOLD TO:
COPPER & BRASS SALES
ATTN: ACCOUNTS PAYABLE
P.O. Box 5116
SOUTHFIELD, MI 48086

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4080397

4080397 610604-5 830324

CUSTOMER PO NUMBER:		WORK PACKAGE:		CUSTOMER PART NUMBER:		SHIP RUN/LOAD ID:	GOV'T CONTRACT NUMBER:
CN5004		061825-6		100828/18			
KAISER ORDER NO:	LINE ITEM:	SHIP DATE:	ALLOY:	CLAD:	TEMPER:	PRODUCT DESCRIPTION:	
1043478	1	9-NOV-2006	2024	BARE	T3	MILL FINISH SHEET	
WEIGHT SHIPPED:	QUANTITY:	B/L NUMBER:	GAUGE:	WIDTH:	LENGTH:		
3990 LB	143 PCS EST.	2010362	0.0400 IN	48.000 IN	144.000 IN		

Certified Specifications

AMS 4037/RevN

AMS-QQ-A-250/4/RevA

ASTM B 209/Rev06

Test Code: 1504

Test Results

Lot: 380935A7 Cast 351

Drop 40

Ingot 3

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %						
	T3	LT / 2 (Min:Max)	67.7 : 68.0 (467 : 469)	46.6 : 46.8 (321 : 323)	15.3 : 16.4						
Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER
Actual	0.09	0.28	4.51	0.59	1.43	0.03	0.16	0.02	0.01	0.00	TOT 0.05

ALLOY LIMITS

Chemistry:	SI	FE	CU	MN	MG	CR	ZN	TI	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.90	1.80	0.10	0.25	0.15	0.05	0.05	TOT	0.15

Aluminum Remainder

CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED AND MANUFACTURED IN THE U.S.A. AND HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT-TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS ARE ON FILE, SUBJECT TO EXAMINATION. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULANT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED

BILL POYNOR, LABORATORIES SUPERVISOR

Bill Poyner